



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-A-1A
Job Sheet 189331



Part No: RBE350A94-3700-A-1A

Job Qty: 12 pcs

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/8/19	2/8/19	0.00	0.00	Start Up Small Fab-2		MLC
95	Small Fab - 2 - B4B	12 pcs	2/8/19	2/8/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLC
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	Small Fab - 1	12 pcs	2/8/19	2/8/19	0.00	1.20	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	12 pcs	2/8/19	2/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

DAS
58 FEB 12 2019
9-89

1	130	Packaging 3-1 - Stock - B4B	12 pcs	2/8/19	0.00 0.00	QC 5 - 30	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	MCC
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	DAS
	140	QC 21 - SA	12 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	21
						QC 21 - SA - 70	9-99
						QC 21 - SA - 53	

FEB 12 2019 GA

Part Op 95 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 2 -Loctite 262 B_____ Exp:_____ -See Descriptions: note 1

110 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 2 -Loctite 262 B_____ Exp:_____ -See note 1

120 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-1 (Identify as per dwg & Stock Location:_____)

140 - QC21 (QC21- Final Inspection - Work Order Release)

See old w/o

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	24 Ea (2 ea)	90-Start up Operation	
92905A225	Extended Point Set Screw, Dog Point	12 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	15.6000 ft (1.3 ea)	90-Start up Operation	
NAS1756-12	Remove Before Flight	12 Ea (1 ea)	90-Start up Operation	
RBE350A94-3700-A-01	Tube	12 pcs (1 ea)	90-Start up Operation	
RBE350A94-3700-A-03	Top	12 pcs (1 ea)	90-Start up Operation	
RBE350A94-3700-A-05	Foot	12 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	24	748	0
	92905A225	12	60	0
	CL-2-C	16	458	0
	NAS1756-12	12	463	0
	RBE350A94-3700-A-01	12	19	0
	RBE350A94-3700-A-03	12	33	0
	RBE350A94-3700-A-05	12	40	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-A-1A
Job Sheet 189331



Part No: RBE350A94-3700-A-1A

Job Qty: 25 ea **12**

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19 **Feb 20**

Created By: Marie Lajeunesse

Type: Stock **50**

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea		2/8/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	25 pcs		2/8/19	0.00	2.50	Small Fab-3		
120	QC	25 pcs		2/8/19	0.00	0.00	QC5		
130	Packaging	25 pcs		2/8/19	0.00	0.00	Packaging3-1		
140	QC21-SA	25 Ea		2/8/19	0.00	0.00	QC21		

Part Op Descriptions: 110 - Assemble as per DWG. Sheet 2 -Loctite 262 B **M138404** Exp: **4/20** -See note 1
25 ea FEB 12/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	24 50 Ea (2 ea)	90-Start up Operation	5122137
92905A225	Extended Point Set Screw, Dog Point	12 25 Ea (1 ea)	90-Start up Operation	10X5093332 2X 5051496
CL-2-C	Lanyard Wire	32.5000 ft (1.3 ea)	90-Start up Operation	5119833
NAS1756-12	Remove Before Flight	12 25 Ea (1 ea)	90-Start up Operation	5134216
RBE350A94-3700-A-01	Tube	12 25 pcs (1 ea)	90-Start up Operation	5136772
RBE350A94-3700-A-03	Top	12 25 pcs (1 ea)	90-Start up Operation	5145074
RBE350A94-3700-A-05	Foot	12 25 pcs (1 ea)	90-Start up Operation	10X5105240 2X 5080303

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	50	618	0
	92905A225	25	72	0
	CL-2-C	33	493	0
	NAS1756-12	25	486	0
	RBE350A94-3700-A-01	25	31	0
	RBE350A94-3700-A-03	25	45	0
	RBE350A94-3700-A-05	25	12	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

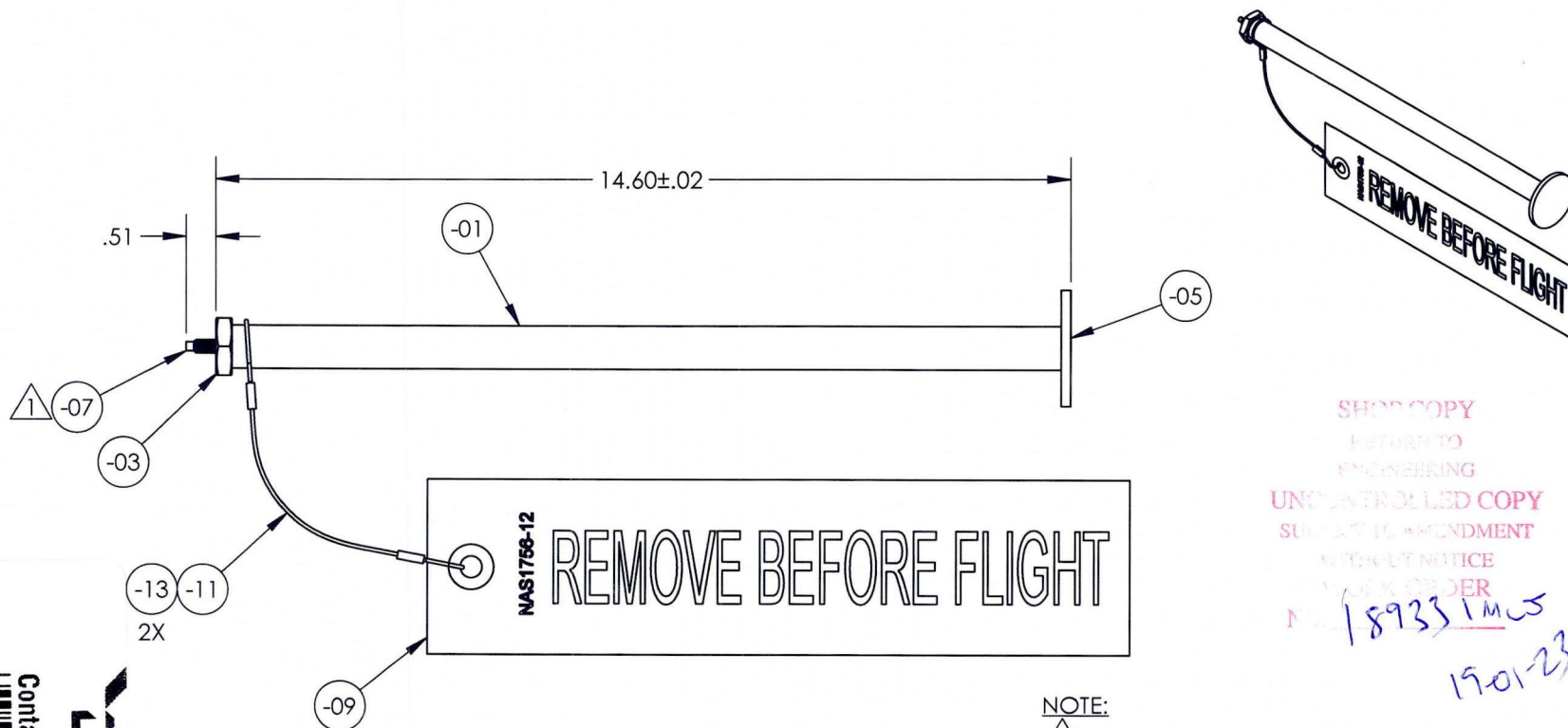
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0282	-1A ADDED TO BOM QTY: 3. ADDED DRAWING.	1/3/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
CHECK ORDER
189331 MWS
19-01-23

NOTE:

1 APPLY LOCTITE 262 TO MATING THREADS OF -03 CAP & -07 EXTENDED POINT SET SCREW, DOG POINT.

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-1A	REV 7
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	XXX ± .005 FRACTIONS ± 1/8
SPEC	XX ± .01 ANGLES ± 5°
	X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 8/21/2012 SHEET 2 OF 5

LONG BRACE ASSEMBLY

DART
AEROSPACE
Container No: S152818
Part: RBE350A94-3700-A-1A
Job No: 189331
Serial No/Batch: S152818
Revision: 7
Inspector:
Exp Date:
Instructions:

Date: 02/12/19